

Date: Friday, 10/5/2007 7:57:47 AM  
 User: Eric Charbonneau

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	FLANGE ASS'Y		
Job Number	35018			Part Number	D3651043		
Estimate Number	13032			Drawing Number	D3651 UNDER REVIEW		
P.O. Number	:			Project Number	N/A		
This Issue	10/5/2007	S.O. No.	:	Drawing Revision	U/R		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	SMALL /MED FAB	Due Date	10/12/2007	Qty:	2
Previous Run	:			Um:	Each		
Written By	<u>EC</u>						
Checked & Approved By	:						
Comment	Est Rev:A New Issue 07-09-27 DD verified by: EC						

## Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304S24GA	304/316 .025 Sheet	
			
Comment: Qty.: 0.2573 sf(s)/Unit Total : 0.5145 sf(s) 304/316 SS sheet 24 ga (0.025" thick) Batch: <u>105529</u> <u>HB 07-10-9</u> <div style="border: 1px solid black; padding: 5px; display: inline-block;"> <b>CERTIFICATE OF CONFORMITY</b>  <b>REQUIRED</b> </div>			
(FOR D3651-7) <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;">           2.0 <b>WATER JET</b>   </div> <div style="text-align: center;"> <b>FLOW WATER JET</b>   </div> </div>			
Comment: FLOW WATER JET 1-Cut as per Dwg D3651 (D3651-7) Dwg Rev: <u>PRE</u> <u>HB 07-10-9</u> Prog Rev: <u>PRE</u>  2-Deburr if necessary - IDENTIFY AS D3651-7 <u>HB 07-10-9</u> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> <u>50</u> </div> <div style="text-align: center;"> <u>AB</u> </div> </div>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> <u>HB 07-10-9</u> </div> </div>			
4.0	QC8	SECOND CHECK	<b>ENGINEERING APPROVAL</b>
Comment: SECOND CHECK <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> <u>1</u> </div> <div style="text-align: center;"> <u>On 08/10/09</u> </div> </div>			
07.10.10			

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE ASSY

Job Number: 35018

Part Number: D3651043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 M304S24GA 304/316 .025 Sheet



Comment: Qty.: 0.2573 sf(s)/Unit Total : 0.5145 sf(s)

304/316 SS sheet 24 ga (0.025" thick)

Batch: 105529 LB 07-10-9

**CERTIFICATE OF CONFORMITY  
REQUIRED**

(FOR D3651-5)

6.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3651 (D3651-5)

Dwg Rev: PRE

LB 07-10-9

Prog Rev: PDF

2-Deburr if necessary

Identify as D3651-5

LB 07-10-9

7.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



LB 07-10-9

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8.0 QC8 SECOND CHECK



**ENGINEERING  
APPROVAL**



Comment: SECOND CHECK

LB

10/07/10/09

9.0 BRAKE NC NC BRAKE 07.10.10



Comment: NC BRAKE

Form D3651-5 and D3651-7 as per Dwg D3651

10.0 QC5 INSPECT WORK TO CURRENT STEP



**ENGINEERING  
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3651

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE ASS'Y

Job Number: 35018

Part Number: D3651043

Job Number:



Seq. #: Machine Or Operation:

Description:

12.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

13.0 QC5 INSPECT WORK TO CURRENT STEP



ENGINEERING  
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock         
Location: \_\_\_\_\_

FOR ENGINEERING USE ONLY

15.0 QC21 FINAL INSPECTION/W/O RELEASE

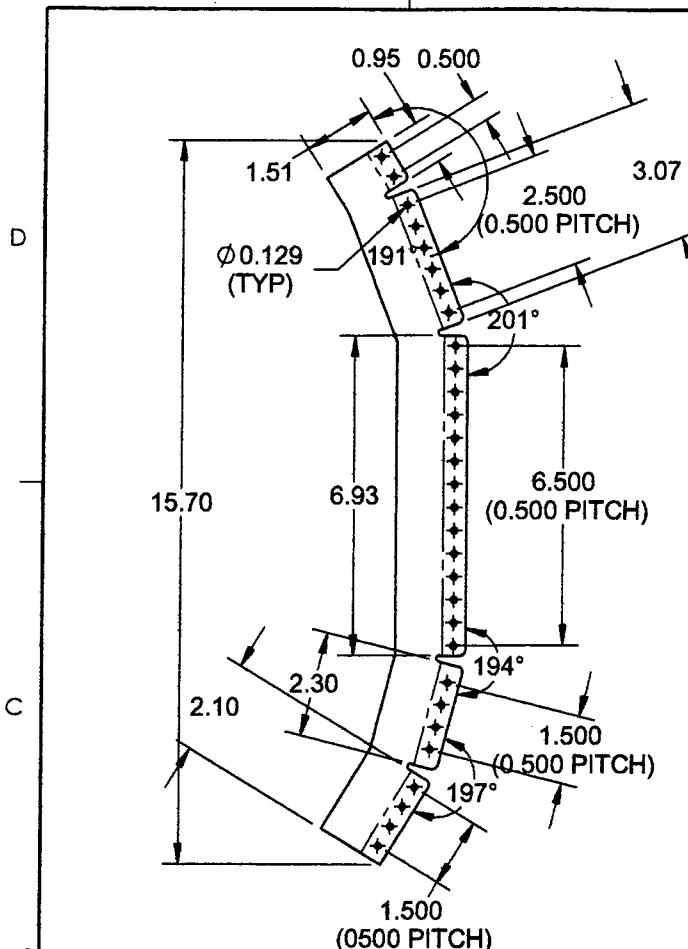


Comment: FINAL INSPECTION/W/O RELEASE

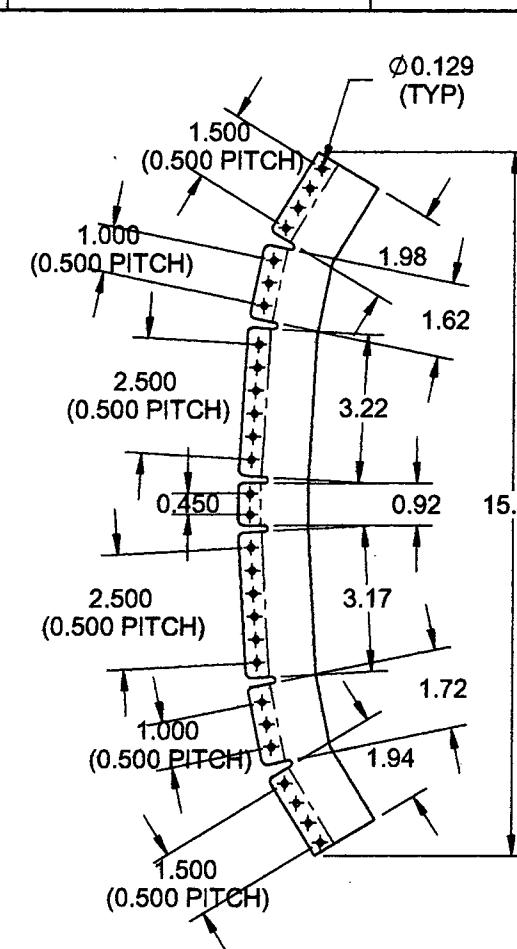
Job Completion



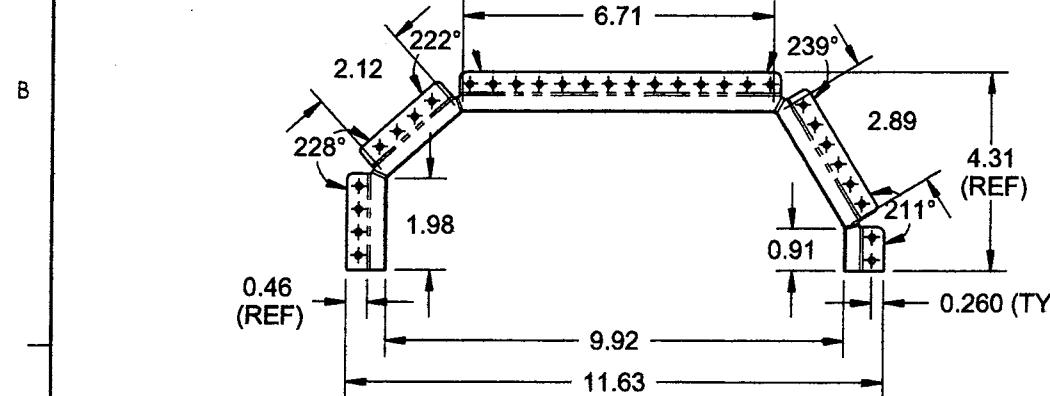
U 571128



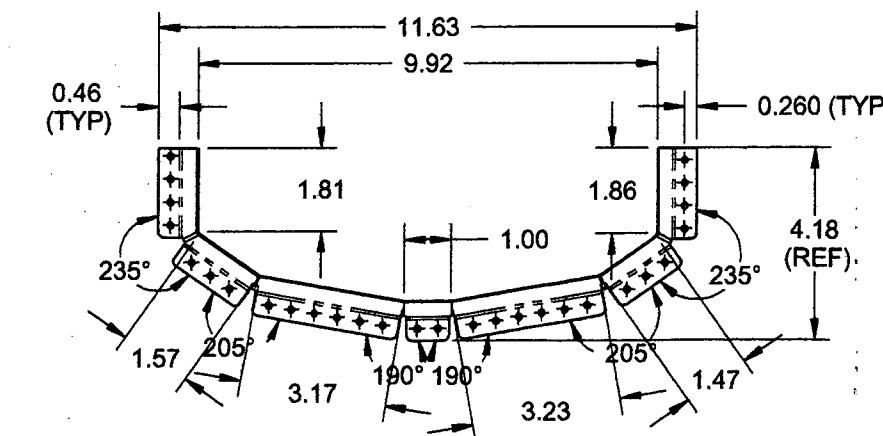
**D3651-5F FLAT PATTERN**



**D3651-7F FLAT PATTERN**



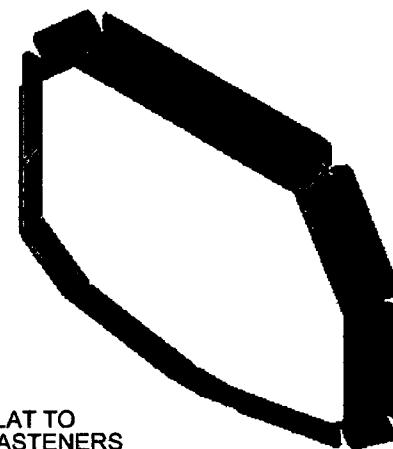
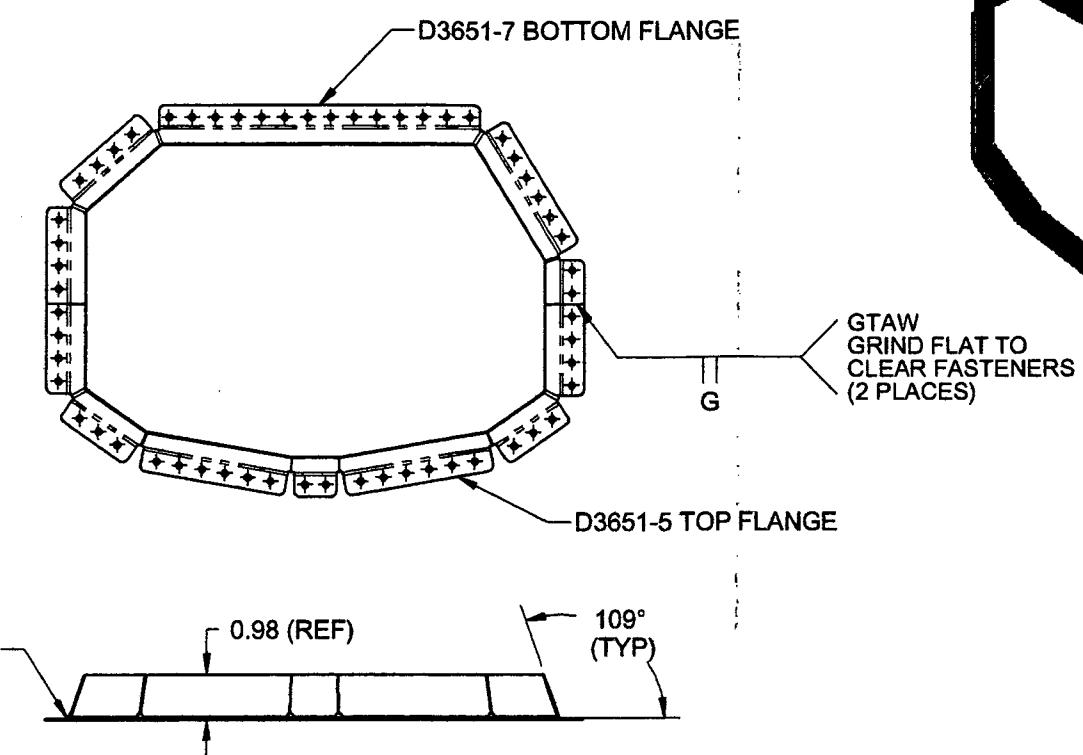
**D3651-5 TOP FLANGE BEND DETAIL**  
(MAKE FROM D3651-5F FLAT PATTERN)



**D3651-7 TOP FLANGE BEND DETAIL**  
(MAKE FROM D3651-7F FLAT PATTERN)

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.025 (24 GAUGE) SHEET, PER MIL-S-5019  
(REF. DART SPEC. M304S24GA)
- 2) FINISH: NONE
- 3) WELD PER QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) MACHINE PER DRAWING "D3651.A4"



DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED	DRAWING NO. <b>D3651</b>
DATE 07.09.10	TITLE AFT BASE	REV. A SHEET 4 OF 5 SCALE 1:4
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DART AEROSPACE LTD	Work Order:	35018
Description: FLANGE ASSEMBLY	Part Number:	D3651- <del>53</del> <sup>5</sup>
Inspection Dwg: 3651 Rev: _____		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: HB	Audited by: ER	Prototype Approval: ✓
Date: 07-10-09	Date: 07/10/09	Date: 07.10.10

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	35018
Description: FLANGE ASSEMBLY	Part Number:	3651-7
Inspection Dwg: 3651	Rev: PRE	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>HB</u>	Audited by: <u>Er</u>	Prototype Approval: <u>12</u>
Date: <u>07-10-09</u>	Date: <u>07/10/09</u>	Date: <u>04-10-10</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Hawksbury, Ontario K6A 1K7  
Phone: (613) 632-3336  
Fax: (613) 632-4443

Purchase From:

Campi Steel  
935 Boul. Du Havre  
Valleyfield, QC J6S 5L1

Ship To:

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-CAM002	PO00004550

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M304S24GA	304/316 .025 Sheet PER MIL-S-5019 (ANNEALED ) 2 B FINISH MATERIAL: AISI 304/316 SS SHEET B/N105592 .	96.0000	sf	5.600000	537.60	Sep 13, 2007

Comments:

10004 BV104  
**Certificate of Mill Test Results**  
 BL TO-003691-002

23Mar07  
 Pg 1/1

**YI SH MAU CORP.**

INVOICE NO. : FORM 446  
 COMMODITY : PRIME COLD-ROLLED STAINLESS STEEL SHEET  
 SPECIFICATION : AISI 304 ASTM A240/ASME  
 CUSTOMER :

**MILL TEST CERTIFICATE**

**ORIGINAL**

MR. KHUIN AN RD. LIU CHU HEIANG  
 KAOHSIUNG TAIWAN R.O.C.  
 TEL:07/3292886 FAX:07/3292866  
 CERTIFICATE NO: PSC06566  
 DATE OF ISSUE: 07/01/2003  
 PAGE 4

Inox

24 Ja 48 x 96

SIZE	NO.	Weight (N.W.)	Part No.	ID NO.	Physical Properties					Chemical Composition (%)								
					Y.S. (kg/mm <sup>2</sup> )	T.S. (kg/mm <sup>2</sup> )	R.L. (%)	H.R.C.	H.V.	C %	Si %	Mo %	P %	S %	Ni %	C %	N %	
AISI 304L (WITH PAPER INTERLEAVES)																		
20GA/48" X 96"	1	1,013	2,009	TK404411	555722263-1	267	550	55	80	156	4	34	181	27	1	507	1818	49
20GA/48" X 96"	1	1,403	2,080	TK404411	555722263-2	267	550	55	80	156	4	34	181	27	1	507	1818	48
20GA/48" X 96"	1	1,404	2,080	TK404411	555722263-3	267	550	55	80	156	4	34	181	27	1	507	1818	48
24GA/48" X 96"	1	1,518	2,545	TK404390	555722263-02	267	552	56	80	156	4	34	181	27	1	507	1818	48
24GA/48" X 96"	2	1,617	2,545	TK404390	555722263-23	268	571	57	80	156	4.2	35	187	25	1	503	1810	5
24GA/48" X 96"	1	1,476	2,334	TK404390	555722263-34	268	571	57	80	156	4.2	35	187	25	1	503	1810	5
<b>TOTAL:</b>		8	8,710															

Remarks: NO MERCURY CONTAMINATION  
 WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS  
 BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

Exhibit for Mill Test No.

**YI SH MAU CORP.**

*Lin Kuan Hsiung*  
 Manager of Quality Assurance Section